

Date: Monday, 2/4/2008 11:22:55 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BATTERY LOCK CASHING
Job Number : 37149	
Estimate Number : 10474	
P.O. Number :	Part Number : D33931
This Issue : 2/4/2008 S.O. No. :	Drawing Number : D3393 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 35808	Material :
Written By : <u> </u>	Due Date : 2/15/2008
Checked & Approved By : <u> </u>	Qty: 20 Um: Each
Comment : Est. A 05.02.18 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5"
-----	--------------------	-------------------------



Comment: Qty.: 0.2843 f(s)/Unit Total : 5.6868 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)

(M6061T6B1.500x01.500)

Batch: 3184736 08.02.13(20)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank: 1.500" x 1.500" x 3.125" long

Machine D3393-1 as per Folio FA510 and Dwg D3393

Identify as D3393-1

Deburr

36 08.02.13(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

36 08.02.13(20)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

36 08.02.13(20)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

3608.02.13(20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
13.02.13	3	step 3 should be machining on the Hears mill The operation is missing on the w/o	36	08.02.13				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: P Date: 08/01/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:22:55 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK CASHING

Job Number: 37149

Part Number: D33931

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M118052



(20X)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

m-1

08/02/15

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HD



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-15

(20X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST487

08-08/02/19

(x20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/19

(20X)

Job Completion



08-02-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Battery Lock Casing		Part Number:	D3393-1
Inspection Dwg: D3393 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+/-0.010	.757	✓			
0.625	+/-0.010	.634	✓			
Ø1.250	+/-0.010	1.250	✓			
1.088	+/-0.010	1.082	✓			
Ø0.734	+/-0.010	.738	✓			
2.658	+/-0.010	2.650	✓			
1.550	+/-0.010	1.550	✓			
0.125 x 45°	+/-0.010	.125 x 45°	✓			
1.50	+/-0.030	1.491	✓			
0.750	+/-0.010	.745	✓			
Ø1.050	+/-0.010	1.050	✓			
Ø1.000	+/-0.010	1.000	✓			
0.338	+/-0.010	.332	✓			
0.563	+/-0.010	.573	✓			
0.100	+0.000/-0.010	.099	✓			
3.00	+/-0.030	3.005	✓			
1.500	+/-0.010	1.506	✓			
0.375	+/-0.010	.370	✓			
1.25	+/-0.030	1.240	✓			
0.125	+/-0.010	.125	✓			
30°	0.5°	30°	✓			

Measured by: <i>SC</i>	Audited by: <i>JMK</i>	Prototype Approval:	N/A
Date: 08-02-13	Date: 08/02/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM <i>AK</i>	<i>JMK</i>



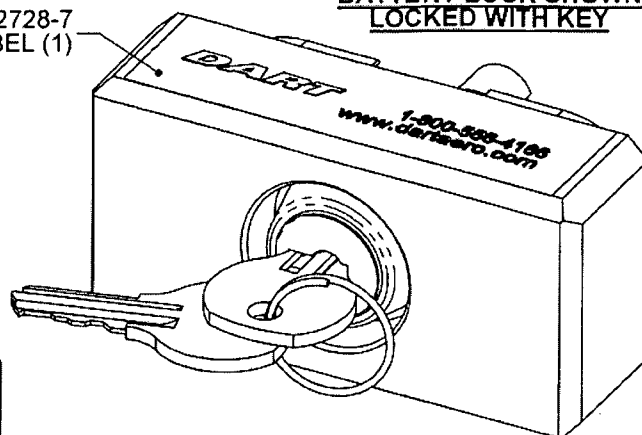
DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]

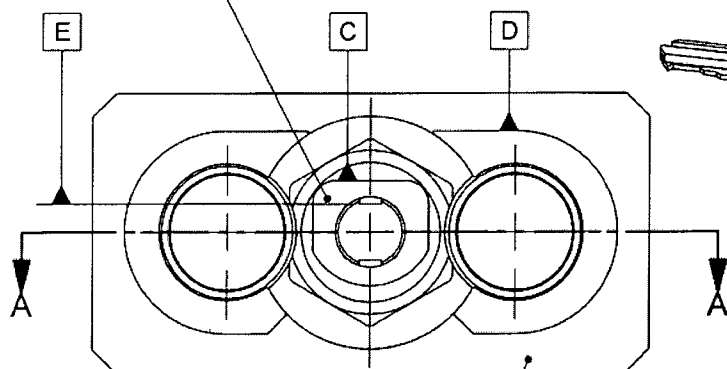
05/03/09

D2728-7
LABEL (1)

BATTERY LOCK SHOWN
LOCKED WITH KEY



POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWN



D3373-1
CAM LOCK
ASSEMBLY (1)

D3393-1
CASING (1)

Ø5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) Δ
AND APPLY KRAZY GLUE

0.09^{+0.03}
-0.01 (2 PLACES)

D3393-3 CAM
LOCK SHAFT (1)

TACK WELD
D3393-3 TO D3369-5

SECTION A-A

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37149

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

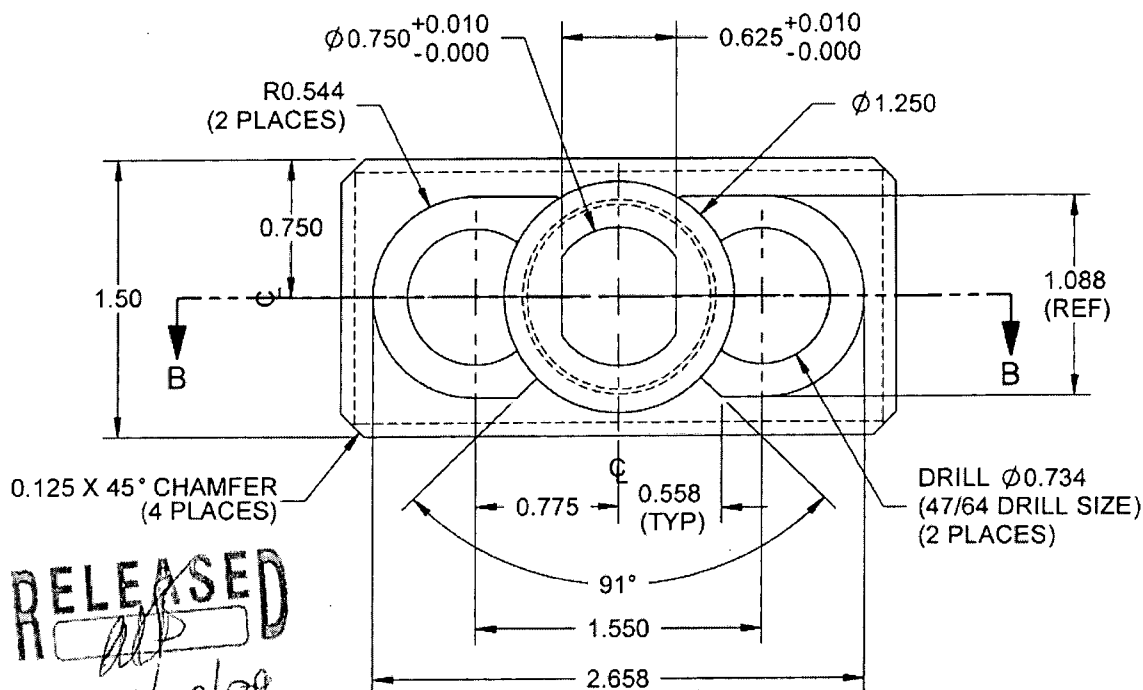
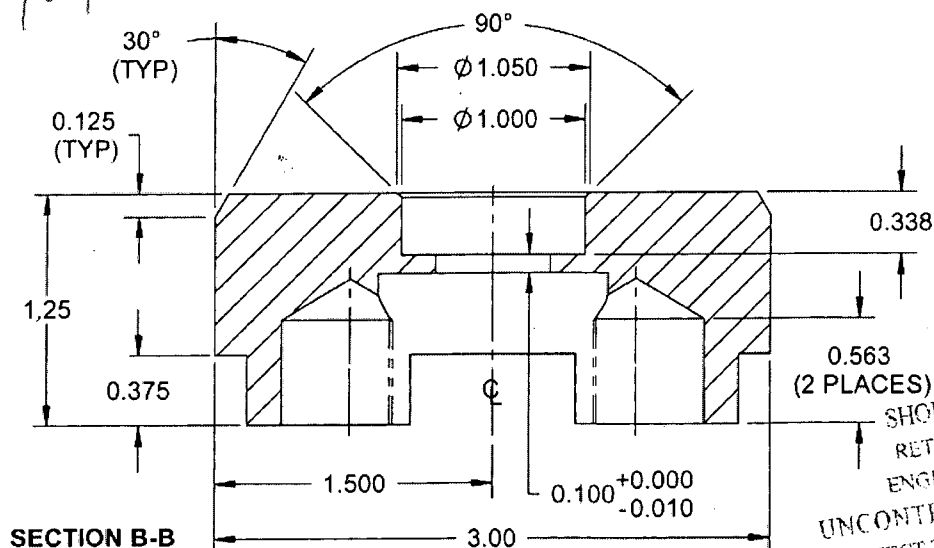
- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMaster-Carr, P/N 9567K21

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1

**RELEASED**
[Signature]
05/03/09**SECTION B-B****D3393-1 CASING****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

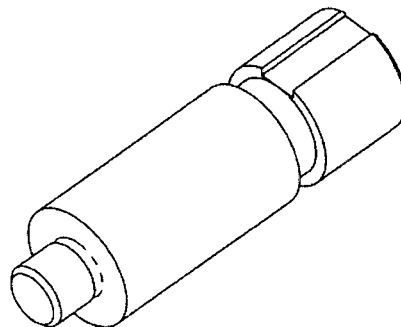
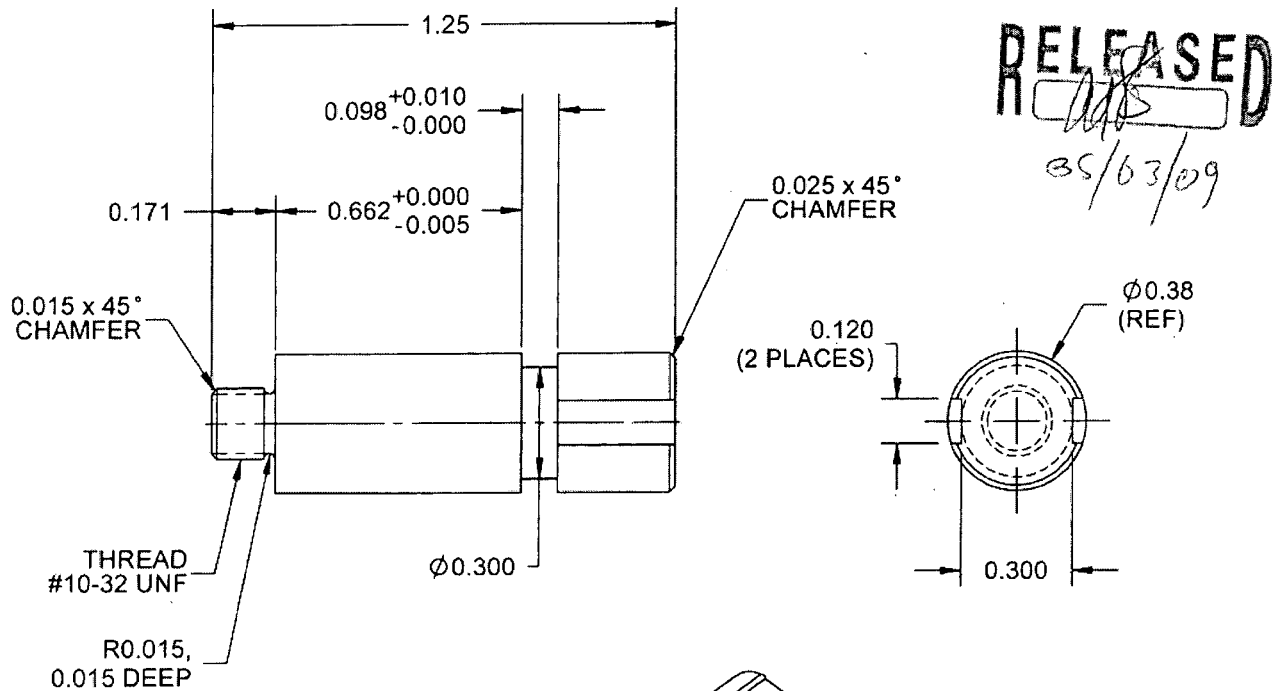
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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